

Work Order ID 68786

Thursday, April 21, 2011 8:06:22 AM



Page 1

Item ID: D412-698-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Support

Start Date: 4/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 4/21/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

-8 ulost62

11-4-28

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/08

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 ulost62

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-015

Location: 12PPP Rev: 10

4/10/3



140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/5/3

ME
11-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:06:28 AM

Page 1

Work Order ID: 68786

Parent Item: D412-698-015

Parent Item Name: Door Support

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10L Washer	NAS1149D0332J	Purchased	No			110	Each	0.0000	12	48			
D3200-1 Door Post Block		Manufactured	No			110	Each	28.0000	2	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST040			28						
				64780			8						
				66676			20						
D3200-3 Door Wedge		Manufactured	No			110	Each	17.0000	2	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST040			17						
				66677			17						
D3201-1 Doubler		Manufactured	No			110	Each	0.0000	2	8			
D3201-3 Doubler		Manufactured	No			110	Each	15.0000	1	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST041			15						
				66679			15						

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:06:28 AM

Work Order ID: 68786

Parent Item: D412-698-015

Parent Item Name: Door Support

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

D3201-4

Manufactured No

110 Each

12.0000

1

4



Doubler

Location

Loc Qty

Loc Code

ST041

12

66680

12

ST041

12

Purchased No

110 Each

2,450.000

12

48

MS21042L3



Nut

Location

Loc Qty

Loc Code

ST300

2450

116391

76

116540

800

116549

774

117441

800

MS24693-S277

Purchased No

110 Each

43.0000

12

48



Screw

Location

Loc Qty

Loc Code

st388

43

117317

43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015-	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

